

{Abstract}

ABSTRACT OF THE DISCLOSURE

The moisture profile and/or moisture gradient of a paper web ~~{for production}~~ of at least SC quality paper **is controlled** in a paper machine comprising a calender (1) which has at least two roll stacks (21, 22; 31, 32), ~~of which at least one~~ **ne stack** has at least three rolls and ~~{of which at least~~ another ~~{one}~~ has at least five rolls, ~~and which calender is provided with a pre-moisturizer (7) placed before the calender, in which pre-moisturizer t}~~. The web is moisturized to a desired pre-moisture content M1 ~~{, and with a}~~ **by a pre-moisturizer (7) before the** **calender**. At least one intermediate moisturizer (3) **is** arranged between two roll stacks **moisturizes the web** to a desired intermediate moisture content M2 before the last roll stack (31, 32), in which the web is dried to a desired final moisture value M3. ~~{In accordance with the invention, f}~~ For continuously controlling and optimizing the moisture profile and/or moisture gradient of the web, the pre-moisturizing W1 of the web is controlled by a ~~{control parameter of the}~~ pre-moisturizer (7) ~~{situated before the calender (1), which}~~ control parameter **which** corresponds to the final moisture value M3 of the web.

(FIG. 1)

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